

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017850**Date Inspected:** 04-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhong Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

WELDING**Segment # 10CW**

This QA inspector observed ZPMC qualified welding personnel identified as 044551 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW11B-002; located On Orthotropic Box Girder (OBG) Side Plate to Side Plate Transverse CJP Joint. ZPMC Quality Control (QC) is identified as Mr. Zhou Peng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1. See the attached Photo

Segment # 11BW

This QA inspector observed ZPMC qualified welding personnel identified as 067609 perform Shielded Metal Arc

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Welding (SMAW), weld joint identified as SEG067A-043; located On Orthotropic Box Girder (OBG) Bottom Plate to Side Plate Transverse CJP Joint. ZPMC Quality Control (QC) is identified as Mr. Zhou Peng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

Segment # 10AE

This QA inspector observed ZPMC qualified welding personnel identified as 040611 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW11-001; located On Orthotropic Box Girder (OBG) FL2 area Transverse CJP Joint. The Welding Repair Report (WRR) was B-WR15480. ZPMC Quality Control (QC) is identified as Mr. Zhou Peng. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-2G (2F) FCM-Repair-1. See the attached Photo.

Segment # 11AE ~ 11BE

This QA inspector observed ZPMC qualified welding personnel identified as 044515 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW11-005; located On Orthotropic Box Girder (OBG) Edge Plate to Edge Plate Transverse CJP Joint. ZPMC Quality Control (QC) is identified as Mr. Zhou Peng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

Segment # 11AE ~ 11BE

This QA inspector observed ZPMC qualified welding personnel identified as 044515 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA081-006; located On Orthotropic Box Girder (OBG) Edge Plate to Edge Plate Transverse CJP Joint. ZPMC Quality Control (QC) is identified as Mr. Zhou Peng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

Segment # 10BE ~ 10CE

During random visual inspection this Caltrans Quality Assurance (QA) inspector observed that American Bridge Fluor (ABF) Quality Assurance (QA) personnel had performed Ultrasonic Testing (UT) on Bottom Plate to Side Plate Hold Back Weld in OBG segment 11AW.

HEAT STRAIGHTENING

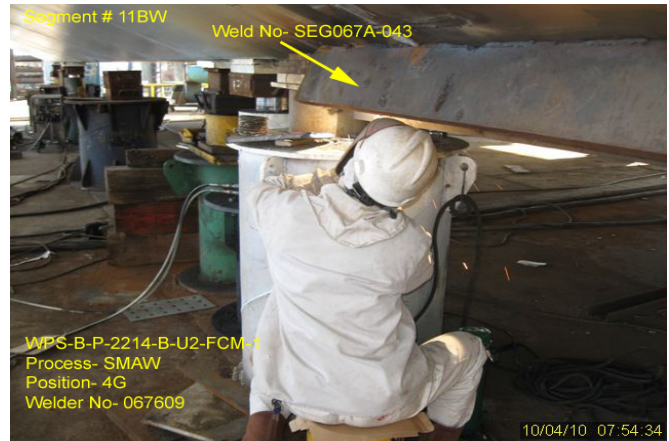
This QA Inspector observed the following work in progress:

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) member identified as Traveler Rail. Distortion appeared to be caused by Welding. ZPMC Quality Control (QC) inspector identified as Mr. Zhu Zhong Hai was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report HSR1 (B) 9508.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
